



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4635-142
Job Sheet 167085-F



Part No: D4635-142

Job Qty: 1 ea

Part Name: Fwd Ceiling Replacement Panel Assembly, RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/24/17

Job Tracking No:

Due Date: 11/10/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea		11/9/17	0.00	0.00	il Start Up Small Fab	
100	Small Fab	1 pcs		11/9/17	0.00	0.80	n Small Fab	
110	Small Fab	1 pcs		11/10/17	0.00	0.80	Small Fab	
120	QC	1 pcs		11/10/17	0.00	0.00	QC5	
130	Packaging	1 pcs		11/10/17	0.00	0.00	iv Packaging3	
140	QC21-SA	1 Ea		11/10/17	0.00	0.00	QC21	

Part Op 100 - Pick Kit

Descriptions: 110 - Assemble as per Dwg D4635-142 Bond foam core to inside of panel 3M Scotch Weld 1300

Batch: _____ 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # _____ Expiry Date _____ 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer(see note 9) Batch: _____

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation 5026606	- D4635-2 5026260	1	2	0	0
	- D4669-1	2	27	0	0
	- D4695-042 5021349	1	1	0	0
	- D4732-3 5022874	1	4	0	0
	- D4732-31 5022872	1	4	0	0
	- D4732-35 5022871	1	5	0	0
	- D4732-7 5022860	1	2	0	0
	- D5022-1 5025247	1	4	0	0

Part Specifications

Specifications could not be found.

Plex 10/24/17 10:43 AM dart.poulin.mario

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																
Date : _____ Descr _____	Job No: 167085-F Mfg Date: 12/22/17			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																														
S027120 167053-F PART NO: D4635-142 Operation: Start up Operation Revision: Change No: Fwd Ceiling Replacement Panel Assembly, RH S026608 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com																																		
Root Cause <table style="width:100%; border-collapse: collapse;"> <tr><td style="width:50%;">Environment</td><td style="width:50%; text-align: right;">No ☐</td></tr> <tr><td>Design</td><td style="text-align: right;">Op ☐</td></tr> <tr><td>Doc/Data</td><td style="text-align: right;">Offs ☐</td></tr> <tr><td>Equip/Tooling</td><td style="text-align: right;">Supplier ☐</td></tr> <tr><td>Handling/Pre</td><td style="text-align: right;">Training ☐</td></tr> <tr><td>Material</td><td style="text-align: right;">Use for Testing ☐</td></tr> <tr><td>Internal Transport</td><td style="text-align: right;">Poor Information ☐</td></tr> <tr><td>Tribal Knowledge</td><td style="text-align: right;">Rushing ☐</td></tr> <tr><td>LOA</td><td style="text-align: right;">Product Improvement ☐</td></tr> <tr><td>Substation</td><td style="text-align: right;">Process Improvement ☐</td></tr> <tr><td>Past Expiry Date</td><td style="text-align: right;">Manufacturing Process ☐</td></tr> <tr><td>Misidentified</td><td style="text-align: right;">Past Due ☐</td></tr> </table>	Environment	No ☐	Design	Op ☐	Doc/Data	Offs ☐	Equip/Tooling	Supplier ☐	Handling/Pre	Training ☐	Material	Use for Testing ☐	Internal Transport	Poor Information ☐	Tribal Knowledge	Rushing ☐	LOA	Product Improvement ☐	Substation	Process Improvement ☐	Past Expiry Date	Manufacturing Process ☐	Misidentified	Past Due ☐	<table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:33%; vertical-align: top;"> ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter </td> <td style="width:33%; vertical-align: top;"> ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes </td> <td style="width:33%; vertical-align: top;"> ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center </td> </tr> <tr> <td colspan="3" style="text-align: center;"> ☐ Loss/Surge /Program ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence </td> </tr> </table>				☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter	☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes	☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center	☐ Loss/Surge /Program ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence		
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